



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2743

Job Sheet 196229



Part No: D2743

Job Qty: 200 pcs

Part Name: Crossbolt Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/10/19

Job Tracking No:

Due Date: 6/27/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP E 05.04.13 Reformat; removed tumble and deburr step KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	200 pcs	6/27/19	6/27/19	0.01	4.28	Hardinge - 1		6/10/19
110	QC 2	200 pcs	6/27/19	6/27/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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DAS
65
9-89

120 QC 8	200 pcs	6/27/19	0.00 0.00	QC 2 - 65	19/06/29
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	19/07/02
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
160 Packaging 3-1 - Stock - B4B	200 pcs	6/27/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	

				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	200 pcs	6/27/19	0.00 0.00	QC 21 - SA - 21	DAS 21 JUL 13 2019
				QC 21 - SA - 70	9-89
				QC 21 - SA - 53	
Part Op 100 - (Hardinge) 1-TURN AS PER FOLIO FA202 & DWG D2743 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 160 - (Identify as per dwg & Stock Location: <u>1600</u>) ***STOCK IN SKIDTUBE CELL *** 170 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6T0.625W.065	6061-T6 Round Tube .625 X.065W	53.3400 ft (.2667 ea)	100-Hardinge - 1	5152404	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Hardinge - 1	M6061T6T0.625W.065	53	41	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Cross Bolt Spacer	3.085inches + 0.030 - 0.000	3.115 3.085		
2	Cross Bolt Spacer	0.625inches ± 0.010	0.635 0.615		
3	Cross Bolt Spacer	0.050inches ± 0.010	0.060 0.040		
4	Cross Bolt Spacer	45.000Degrees ± 0.000	45.000 45.000		
5	Cross Bolt Spacer	0.065inches ± 0.010	0.075 0.055		

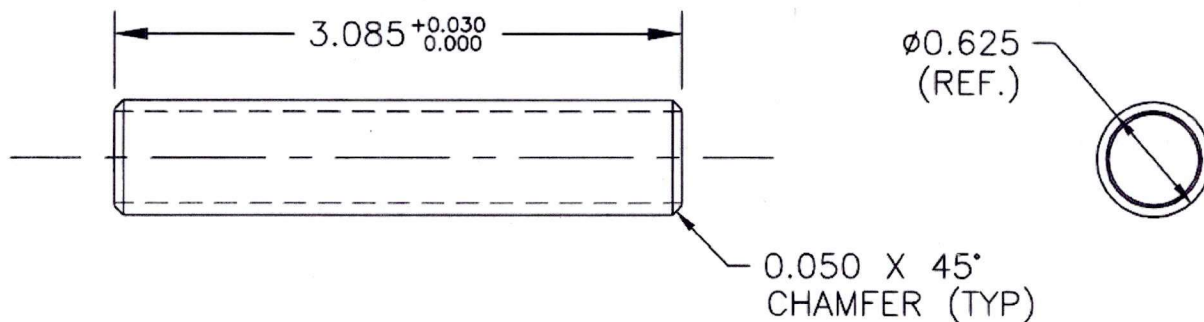
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DESIGN <i>W</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>W</i>	APPROVED <i>KE</i>	DRAWING NO. D2743	REV. B SHEET 1 OF 1
DATE 98.12.08		TITLE CROSS BOLT SPACER SCALE 1:1	
A	98.04.16	NEW ISSUE	
B	98.12.08	3.085 WAS 3.060	

RELEASED
98.2.16 DS

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 196178 ML5
1906-07



MATERIAL: 6061-T6 (WW-T-700/6) 0.625 DIA. X 0.065 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S194932



Part: D2743

Job No: 196229

Serial No/Batch: S194932

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 06/29/19